

54619 / DREV

Work Order ID 52366

September 22, 2009 10:50:17 AM



Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 09-09-22 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3887	B
IIN-D119-646	B

100

0.00



DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D119-646-241 CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Page 2

Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo 1- Remove 45,3125" from D2500-1-180
0.00 190

1- Bend FWD end of tube using Bender 1 and bend prog D3887 FWD per dwg. D3887

2- Cut FWD end of tube as per dwg D3887. ✓

3- Cut AFT end of tube as per dwg D3887. ✓

4- Buff out marks left from bending, *debur ends*

5- Drill Aft cap pilot hole using DT _____ ***DO NOT OPEN TO FINISHED SIZE***

6- Cleco DT _____ in position and install drill Jig DT 9477 drill X-bolt spacer ✓
pilot holes using 3/16" drill

7- Drill FWD cap holes using DT 8215 Open FWD & AFT cap holes to 0.208" ✓

8- Drill FWD holes *holes must be laid out manually*

9- Drill Tow ring hole using DT _____ Open to finished size. *holes must be laid out manually*

10--Drill wearplate holes

11- Deburr

DD
9-11-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Page 3

Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 ✓ Memo	0.00 0.00				1	49/11/09		
121 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				①	8E 09/11/09		
122 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			09-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Memo

0.00

1-Open crossbolt spacer holes to finished size.

2-Deburr crossbolt spacer holes as per Dwg D3887 and blow out chips from inside the tube

7 H 9/11/10

140

0.00



Skidtubes

Memo

0.00

1-Bond web in place as per Dwg D3887 & QSI 015.

A/R ☐ Sikaflex-291 ☒ 112391 ☐

Sikaflex expire date: ☐ 02/20/10 ☐

Start: ☒ 09/11/10 ☐ Time: ☒ 8:30 ☐

Finish: ☒ 09/11/12 ☐ Time: ☒ 7:00 ☐

***** (Adhere for 12 hours) *****

BE 09/11/10

2- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

3- C'sink crossbolt spacer holes, and prepare tube for welding, deburr.

BE 09/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Page 5

Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DP 9-11-12

Memo

0.00

160



Skidtubes

Skidtubes

Memo

1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R ☐ Aluminum Rod M112507 BE 9-11-12

2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole.

3-Counterbore 5/16" x 0.750" deep as per Dwg D3887.

4- Deburr & Scribe batch # on Aft end of tube.

) H 9/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Page 6

Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

⇒ S.02/11/12



QC

Memo

0.00

Quality Control



180

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ S.02/11/12



QC

Memo

0.00

Quality Control



190

Pressure Wash per QSI005 4.3

0.00

⇒ S.02/11/12

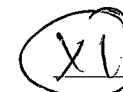


HandFinish

Memo

0.00

Hand Finishing



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Page 7

Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:00AM

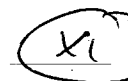
OVEN TEMPERATURE:

320°C

FINISH TIME:

9:30AM

⇒ M112140 09/11/17



210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ 09-12-8.



240

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install wearplates as per Dwg D3887.

✓ 2-Inspect for foreign objects as per QSI 024

3 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-240/-291 ☐ M112345

Sikaflex expire date: ☐ 10/09

⇒ M112140 09/12/09



PTO⇒

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/12/09	241	Add "2" NAS 1149C0332R washers when installing "END-CAPS" M 112314	jd	09/12/09	X2		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM



Item ID: D119-646-241

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 09/24/10

(f1)

q

255

Wing Walk as per dwg QSI005 4.4 Batch 11/12/09

0.00



HandFinish

Memo

0.00

Hand Finishing

W 09/12/10

(XC)

q

256

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

278 09/24/10

(f1)

q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/12/09	241	Install 11/2					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52366

September 22, 2009 10:50:17 AM

Page 9

Item ID: D119-646-241

Accept

Setup Start

Revision ID: B

Stop

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PP 52357

0.00

Packaging

270

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/10/14

H. 09.12.16

PL 09-12-14
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

September 22, 2009 10:50:16 AM

Work Order ID: 52366

Parent Item: D119-646-241RevB

Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/R		Manufactured	No		B50166	110	Each	0.0000	1.0000			
Ext'n - 1" Beam Tube 4"												
D3885-1RevB		Manufactured	No			140	Each	0.0000	1.0000			
Standard Web												
D3903-1RevB		Manufactured	No			160	Each	0.0000	12.0000			
Spacer												
D3681-1RevA		Manufactured	No			160	Each	74.0000	8.0000			
Spacer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47123

48178

74

13

61

D2855-3RevB

Manufactured

No

240

Each

0.0000

2.0000

Cap

(X2)

1 11/11/09

1 B 52421 BE 09/11/10

B 51849 (X12) BE 09/11/12

B BE 09/11/12

B 52281 11/09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

September 22, 2009 10:50:16 AM

Work Order ID: 52366



Parent Item: D119-646-241RevB



Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			240	Each	1,168.000	14.0000		09/12/09	
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1168

111424

8

111707

160

112314

200

112489

100

112641

500

112720

200

M112641 X2 09/12/09

X34 11/05/12/08

D3904-1RevB

Manufactured

No



Washer

240

Each

300.0000

16.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST136

300

51875

300

B 48374

X16 4/09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 10:50:16 AM

Work Order ID: 52366



Parent Item: D119-646-241RevB



Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			240	Each	1,186.000	4.0000			
Phenolic Washer												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

686

39275

19

42329

121

47628

546

Main Warehouse

ST117

500

51674

500

D3849-041RevB

Manufactured

No

240

Each

0.0000

1.0000



FWD WEARPLATE ASSY, STD/FLOAR GEAR

(X1)



B53030 H 09/12/08

D3849-043RevB

Manufactured

No

240

Each

0.0000

1.0000



AFT WEARPLATE ASSY, STD GEAR

(X1)



B52402 H 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 10:50:16 AM

Work Order ID: 52366

Parent Item: D119-646-241RevB

Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 09/30/2009


Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq-ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C46A		Purchased	No			240	Each	98.0000	8.0000			
												
BOLT												

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------


Main Warehouse

ST	98	
----	----	--

106169	5	
--------	---	--

106176	9	
--------	---	--

111918	84	
--------	----	--

MS21043-3		Purchased	No			240	Each	5,320.000	8.0000			
												
Nut												

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

OFFSHORE

FG	80	
----	----	--

103691	80	
--------	----	--

Main Warehouse

ST	5240	
----	------	--

111819	78	
--------	----	--

112243	186	
--------	-----	--

112314	4976	
--------	------	--

x8 09/12/08

x8 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

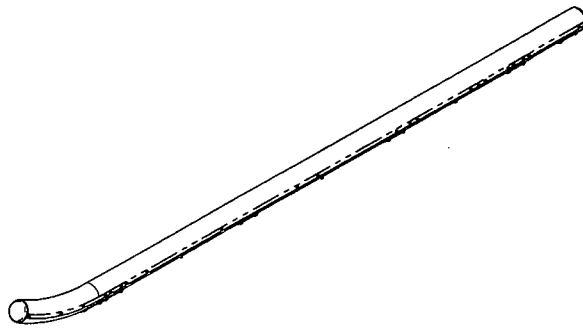
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NAS1611-205

#52366



D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEAPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs
D3887-043 = 37.0 lbs
D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO $\phi 0.197$ HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL $\phi 0.297$ HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-2411-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3887-041	STD SKIDTUBE ASSY WITH WEARPAD
2		X		D3887-043	STD SKIDTUBE ASSY WITH WEARPLATE
3			X	D3887-045	STD SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	5			D3846-1	GASKET
16	1			D3846-11	GASKET
17	5	5		D3847-1	WEARPAD
18	1	1		D3847-11	AFT WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEAPLATE ASSY
21		1		D3847-047	AFT WEARPLATE ASSY
22			1	D3849-041	FWD TRAINING WEARPLATE ASSY
23			1	D3849-043	AFT WEARPLATE ASSY
24	1	1	1	D3885-1	STANDARD WEB
25	1	1		D3887-11	STANDARD SKIDTUBE
26			1	D3887-13	STANDARD SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
41	30	30		ALS4-1032-130	INSERT
42	34	34	4	AN3C5A	BOLT
43			8	AN3C46A	BOLT
44	34	34		NAS1149C0332R	WASHER (OR AN960C10L)
45			8	MS21043-3	NUT

RELEASED
10/16/13

B	ALS4-1032-130 WAS AELS-1032-130, ZN C4-1, C5-7, C3-7; ADD DT8931, ZN A6-1; ADD 134.04, ZN C4-8; D2855-3 WAS D2875 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3887	SHEET 1 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 STD SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a cross-section of a bridge deck, showing various components and dimensions. The drawing includes the following labels and dimensions:

- AN3C5A BOLT**
- D3672-1 PHENOLIC WASHER**
- NAS1149C0332R WASHER (1 PER SIDE)**
- BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE TYP**
- 11**
- Ø 0.197**
- 8 PL PER SIDE REF**
- 1.5** (multiple dimensions)
- 2.00 DISTANCE TO D3885-1 WEB, REF**
- SEAL WITH SIKAFLEX-241/291**
- D2855-3 CAP**
- D3846-11 GASKET**
- D3847-11 WEARPAD**
- AN3C5A BOLT**
- NAS1149C0332R WASHER 24 PL**
- PLUG UNUSED INSERTS WITH AN3C5A BOLT**
- NAS1149C0332R WASHER 6 PL**
- D3846-1 GASKET 5 PL**
- D3847-1 WEARPAD 5 PL**
- AN3C5A BOLT**
- D3672-1 PHENOLIC WASHER**
- NAS1149C0332R WASHER (1 PER SIDE)**

D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3887-11)

RELEASED
8/6/15 MP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3887	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	A119 STD SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED, COPIED, OR NOT BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WHO IS NOT AN EMPLOYEE OF DART AEROSPACE USA, INC.	

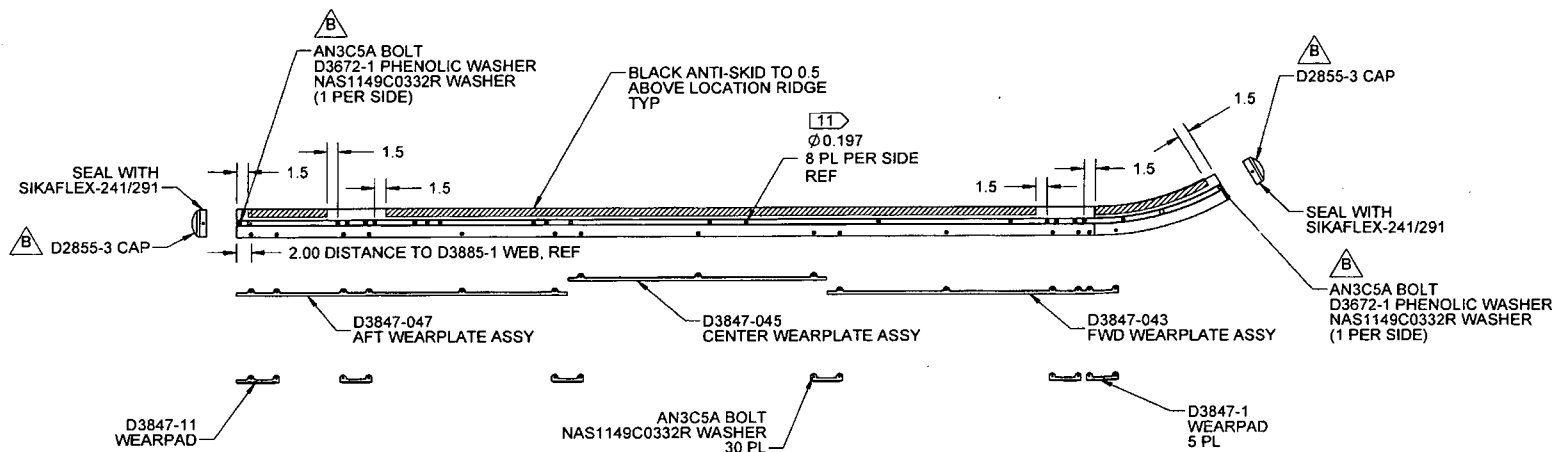
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE
(MAKE FROM D3887-11)

RELEASED
09/07/15 JMD

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3887	REV. B SHEET 3 OF 8
MFG. APPR.	<i>[Signature]</i>	TITLE A119 STD SKIDTUBE ASSY	SCALE NTS
APPROVED	<i>[Signature]</i>	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.	<i>[Signature]</i>		
DATE	09.06.30		

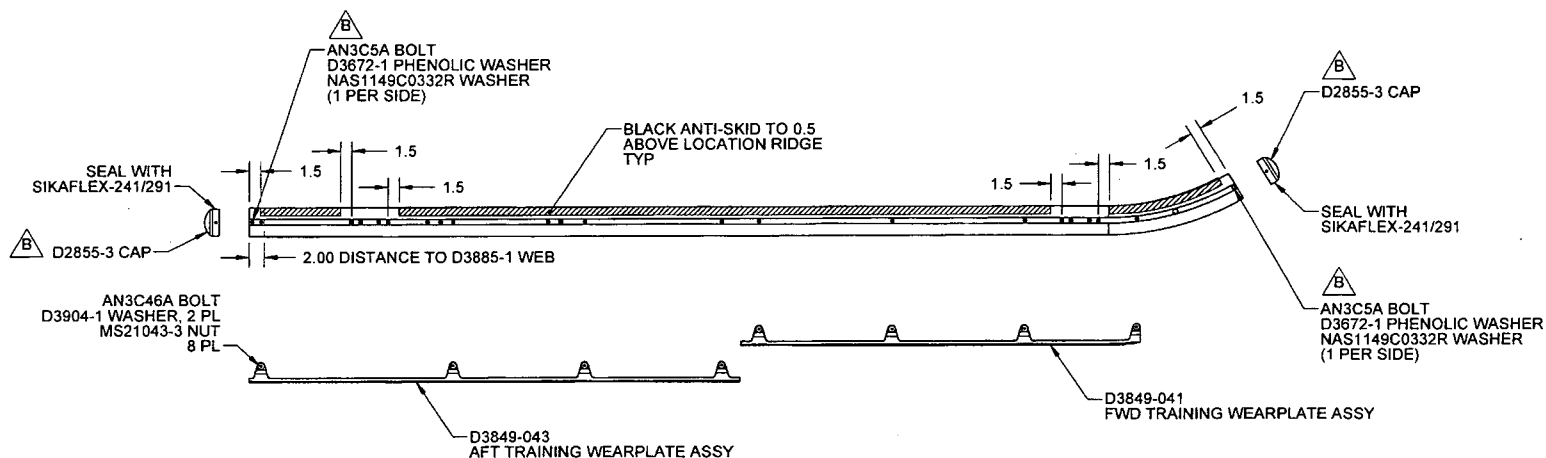
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/12/09							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3387-13)

RELEASED
11/17/14

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3887	REV. B
MFG. APPR.	RF	SHEET 4 OF 8	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 STD SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

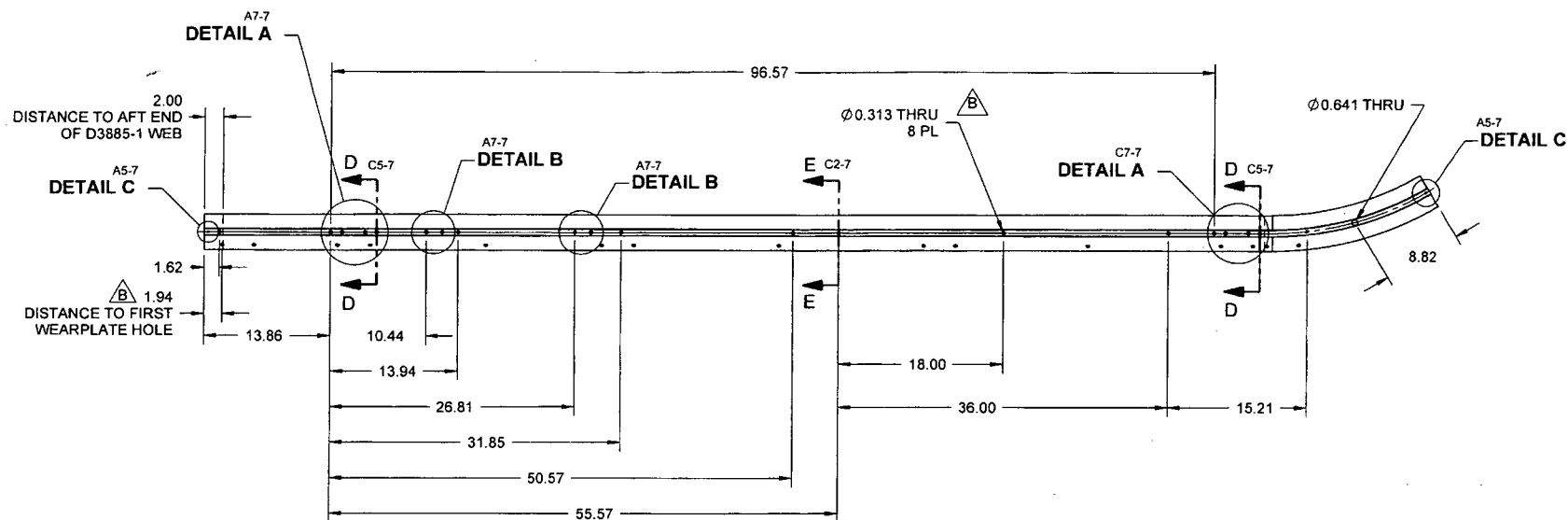
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52366



D3887-11 DRILLING DETAIL
(MAKE FROM D3887-1)

RELEASED
01/15/2010

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3887	REV. B
MFG. APPR.	RF	TITLE	SHEET 5 OF 8
APPROVED	RF	A119 STD SKIDTUBE ASSY	SCALE
DE APPR.	RF		NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

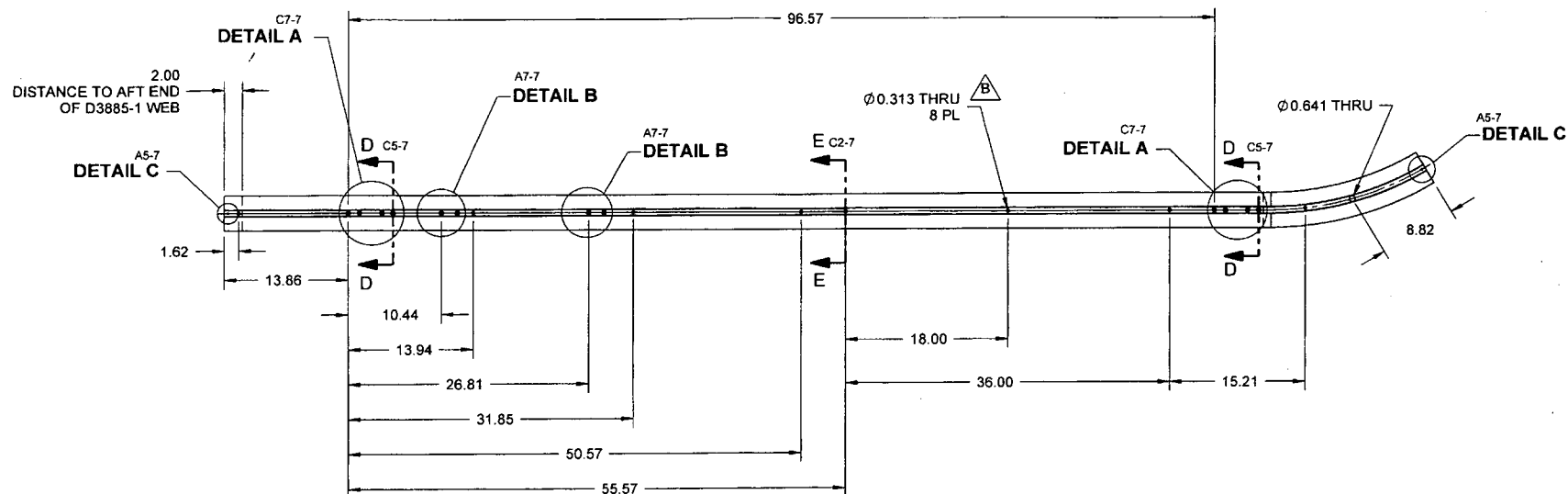
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#52364



D3887-13 DRILLING DETAIL
(MAKE FROM D3887-1)

RELEASED
8/15/13

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3887	REV. B
MFG. APPR.	RF	SHEET 6 OF 8	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 STD SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

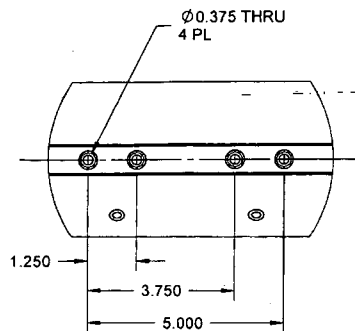
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

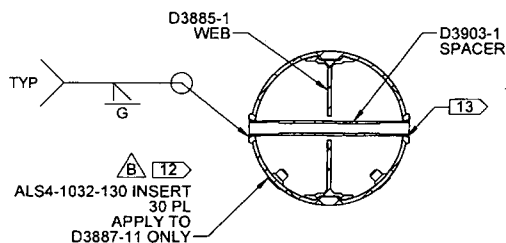
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

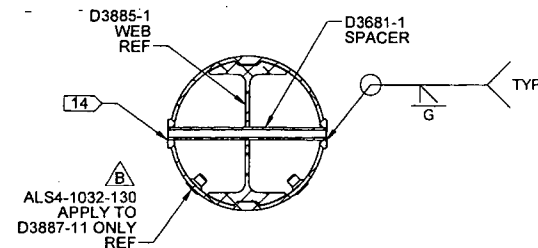
NOTE: Date & initial all entries



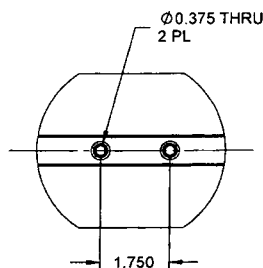
DETAIL A
SCALE 4X
D7-5
C3-5
D7-6
C3-6



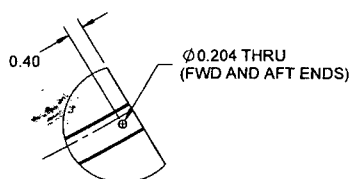
SECTION D-D
SCALE 4X
C7-5
C3-5
C7-6
C2-6
(FOR 12 X ϕ 0.375 HOLES
PER SKIDTUBE)



SECTION E-E
SCALE 4X
C4-5
C4-6
(FOR 8 X ϕ 0.313 HOLES
PER SKIDTUBE)



DETAIL B
SCALE 4X
C5-5
C5-6
C5-6



DETAIL C
SCALE 4X
C8-5
C1-5
C8-6
C1-6

NOTES:

13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR ϕ 0.375 HOLES ONLY:

- i) CHAMFER HOLES ϕ 0.475 x 45°
- ii) INSERT D3903-1 SPACER
- iii) WELD INTO PLACE AND GRIND FLUSH
- iv) C BORE TO 0.313 x 0.75 DEEP
- v) DEBURR HOLES

14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR ϕ 0.313 HOLES ONLY:

- vi) CHAMFER HOLES ϕ 0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
- vii) INSERT D3681-1 SPACER
- viii) WELD INTO PLACE AND GRIND FLUSH
- ix) DEBURR HOLES

RELEASED
09/15/04

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3887	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 STD SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

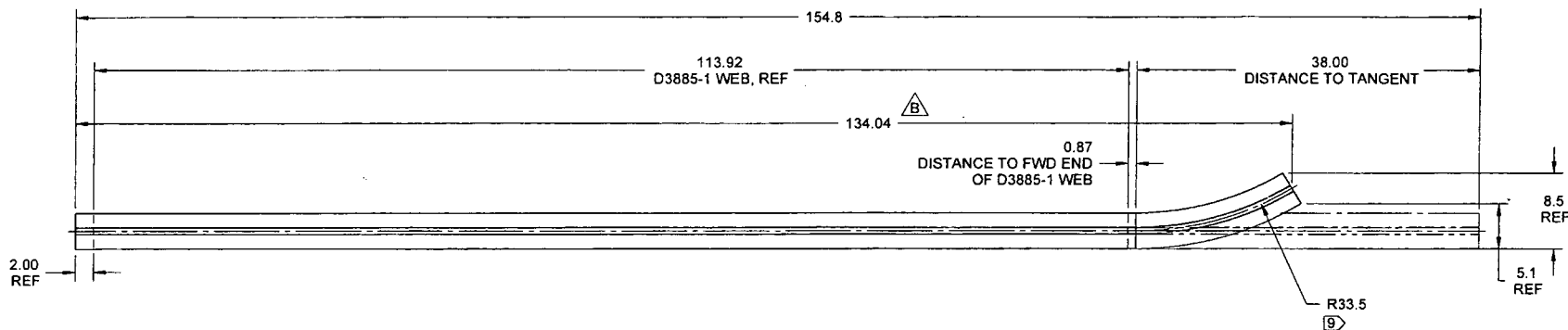
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

#52366



D3887-1 BEND DETAIL
(MAKE FROM D2500-1-190 EXTRUSION)

RELEASED
2/10/15

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3887	REV. B SHEET 8 OF 8
MFG. APPR.	RF	TITLE A119 STD SKIDTUBE ASSY	SCALE NTS
APPROVED	RF	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.	RF		
DATE	09.06.30		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 217

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52996
Part number: D119.646.243
Description: 119 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dymally Date of Test Coupon 09.11.16

Welder Barclay Elliott Date of Test Coupon 09.11.16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

B529%

D119-646-243

REFERENCE ONLY

10/10/20

9-10-20

- 1 - report Hatz D2500-1-190 for damage
- 2 - Envisi Equations of orb
- 3 - Chemical conversion cost per 0.51 per 4.1

QC 3/10
BE 9-10-21

- 1 - metal drilling DT9480 drill all 7 feet
apex hole using 3/16 Drill.
- 2 - acbe batch # inside aft end of tube

- 1 - Bond aft end of tube using CNC Borer
and bond prog D3905 Aft. Aft not use
bonding Aft DT9538. Aft not use
positioned correctly, that the border
set up in on full wide and that
the indexing ridge is covered with
graphite grease.

- 1 - Verify dimension of bond as per drawing 3905

- 2 - Buff out marks left from bonding

- 3 - Drill off Flat Bore hole using DT9493
open using D3905 drill 6 + section F-F
open to finished size

4- Drill Aft Wapost Wapost holes using DT + DT — as per drawing 3905 detail 6.

3- Open X-ball spacer holes to finished size. Open to finished size.

*** Do NOT OPEN FWD SADDLE HOLES ***
size as per drawing 3905 (section D-D + E-E)

4- Debur, blowout chips from inside of tube

5- Bond web in place as per drawing D3905 + Q51015. Allow for 12 hrs.

Sign _____
EPO Date _____
Date _____
Time _____

QCS

1- Bond Fwd end of tube using bond 1 and bond prep D3905 Fwd.

2- Cut Fwd end of tube as per drawing D3905 *** Verify measurement before cutting ***

1- Buffout marks left from bonding

2- Drill Fwd Cap holes using DT 8215 Open Fwd + Aft Cap holes to $\phi 0.308$

3- Open Fwd saddle holes to finished size as per drawing D3905

4- Drill Fwd X-ball hole + Open to finished size. Check must be tied out manually

596
(x10)

595
(Bond 1)

5- Drill turning hole & open to finished
 size (hole must be laid out manually)

70- Debur, blow out chips from inside
 of tube.

6- Open ~~Drill~~ Flat both holes $\Phi 0.391$ (pending 3905
 QC 5/6
 A/R 6 + Section F.F.

1- Counterbore X-bor holes according D3905
 2- Boreline profile prepare for welding

3- insert X-bor spacers

4- weld X-bor spacers
 A/R

5- Grind inside flush

6- C' bore X-bor holes according D3905

7- Debur

QC 5/6

QC 10

PAINT

Seg 7

Seg 8
 (shd)

Seg 9

Seg 10